

Date: Wednesday, 9/12/2007 12:13:34 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL
Job Number	: 34605		
Estimate Number	: 10765		
P.O. Number	:	Part Number	: D32451
This Issue	: 9/12/2007 S.O. No. :	Drawing Number	: D3245 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 33838	Material	:
Written By	:	Due Date	: 10/5/2007 Qty: 8 Um: Each
Checked & Approved By	: <u>07.09.12</u>		
Comment	: Est. A 04.07.07 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S22GA	304/316 .032 Sheet
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Comment: Qty.: 0.8442 sf(s)/Unit Total: 6.7536 sf(s)  
 304/316 .032 Sheet

Batch: M105262 07-09-18

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3245 \*\*\*\*prog.D3245-1/-2\*\*\*\*  
 Dwg Rev: A 07-09-18  
 Prog Rev: A

2-Deburr if necessary 07-09-18

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Deburr if necessary  
 C'sink as per Dwg D3245  
 Form D3245-1 as per Dwg D3245 Identify as D3245-1

Scrap parts  
per ECN 1052

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/18	4 2.0	1 part scrap due to programming error (missing 30 holes)	<i>[Signature]</i>	Fix Program  scrap and destroy and replace	<i>[Signature]</i> 07-09-18	<i>[Signature]</i> 07/01/18	<i>[Signature]</i>	<i>[Signature]</i>
07/01/18	2.0	2 parts scrap origin was all. RC. Human error	<i>[Signature]</i> 07/01/18	Scrap and Destroy and Replace	<i>[Signature]</i> 07-09-18	<i>[Signature]</i> 07/01/18	<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:34 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 34605

Part Number: D32451

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*WOT-11.02*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

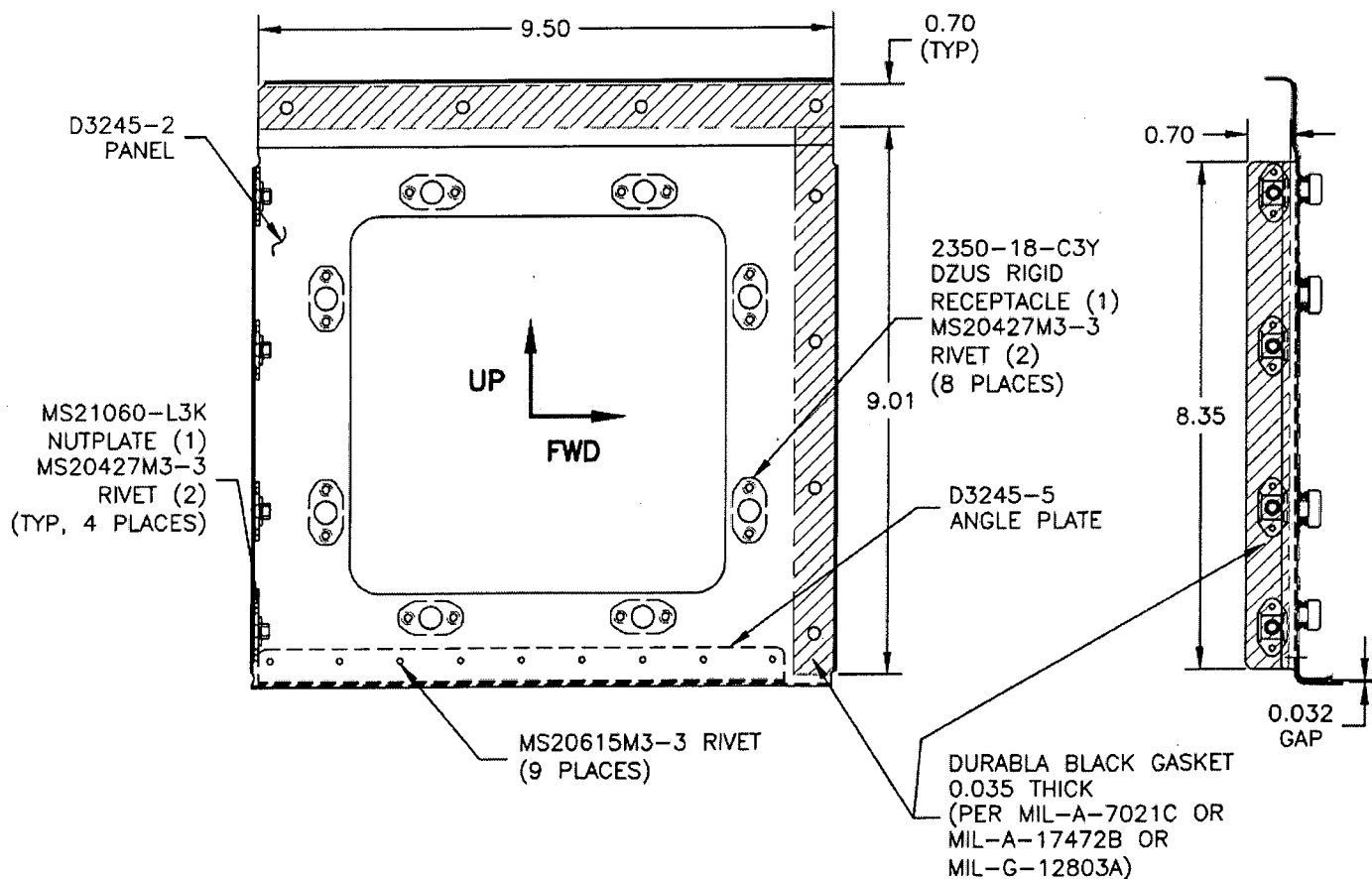


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CHECKED #	APPROVED #	DRAWING NO. D3245	REV. A SHEET 2 OF 6
DATE 04.01.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:3

RELEASED  
04.04.21



### D3245-042 ACCESS PANEL ASSEMBLY

#### D3245-042 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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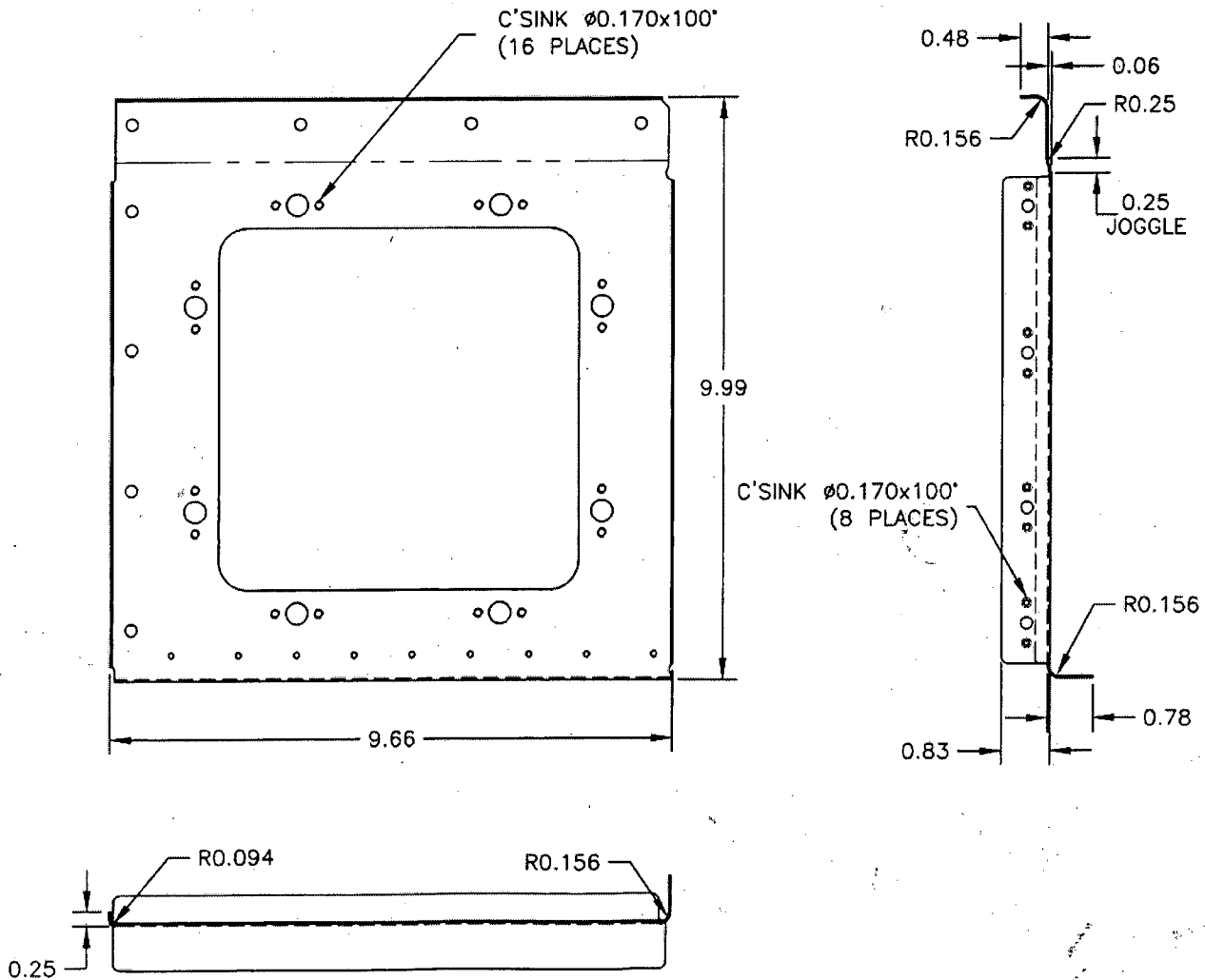
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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:3

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04.04.21



D3245-1 PANEL BEND DETAIL SHOWN  
BEND D3245-2 PANEL OPPOSITE

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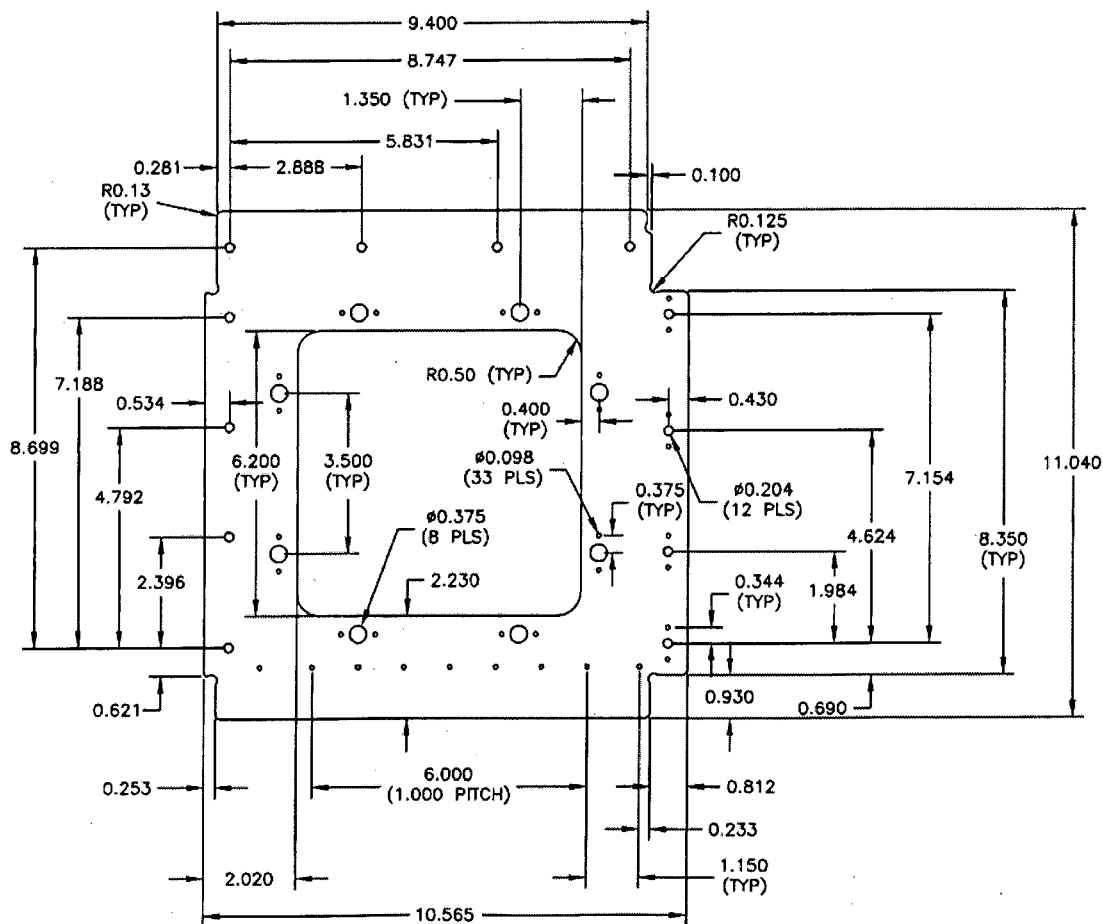
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3245	REV. A SHEET 4 OF 6
DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

RELEASED  
04.04.21 [Signature]



**D3245-1/-2 PANEL FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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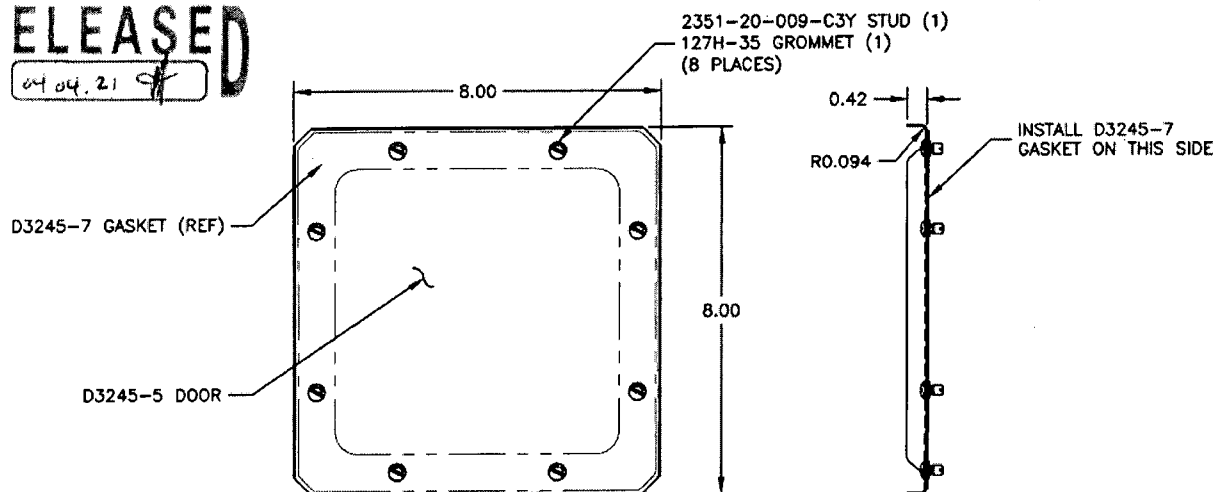
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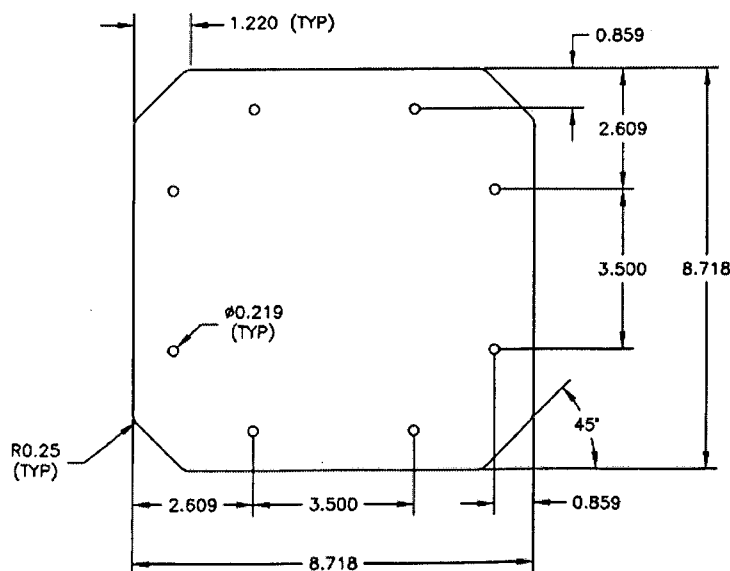


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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

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04.04.21



**D3245-043 DOOR ASSEMBLY**

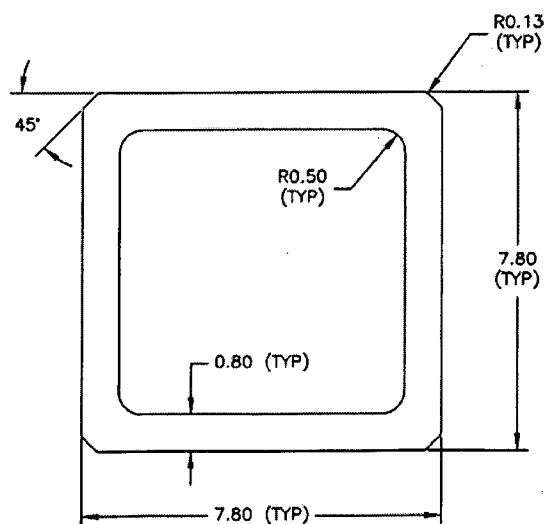


**D3245-3 DOOR FLAT PATTERN**

MATERIAL: AISI 304/316 SS 0.032 THICK  
ANNEALED (REF. M304S22GA)

**D3245-043 NOTES:**

- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH THE MANUFACTURER'S INSTRUCTIONS
- 6) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 7) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER



**D3245-7 GASKET**

MATERIAL: DURABLE BLACK GASKET 0.035 THICK  
(PER. MIL-A-7021C OR MIL-A-17472B  
OR MIL-G-12803A)

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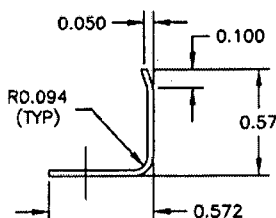
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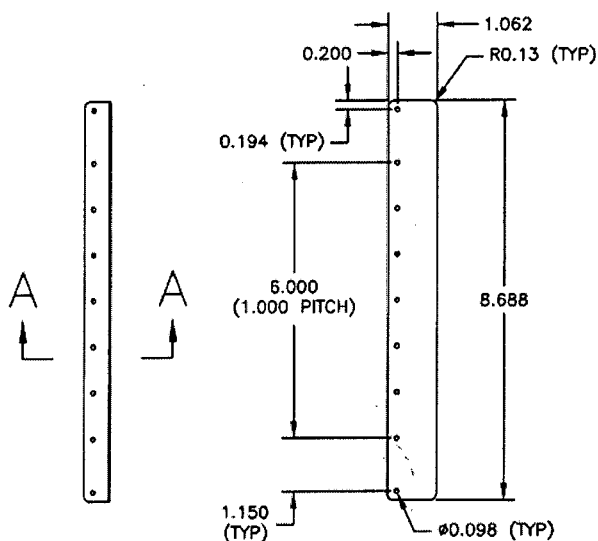


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DATE 04.01.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04-04-05



**D3245-5 BEND DETAIL**  
**VIEW A-A**  
**SCALE 1:1**



**D3245-5 FLAT PATTERN**

**D3245-5 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order:	34605
Description: PANEL		Part Number:	D3245-1
Inspection Dwg: 3245 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .375	+ .006 - .001	.378	*			
Ø .204	+ .005 - .001	.207	*			
Ø .098	+ .004 - .001	.101	*			
6.200	+/- .010	6.200	*			
9.400	+/- .010	9.400	*			
8.747	+/- .010	8.747	*			
5.831	+/- .010	5.831	*			
2.888	+/- .010	2.888	*			
11.040	+/- .010	11.040	*			
8.350	+/- .010	8.350	*			
7.154	+/- .010	7.154	*			
4.624	+/- .010	4.624	*			
1.984	+/- .010	1.984	*			
.930	+/- .010	.930	*			
.690	+/- .010	.690	*			
.812	+/- .010	.810	*			
.233	+/- .010	.233	*			
1.150	+/- .010	1.150	*			
10.565	+/- .010	10.565	*			
6.000	+/- .010	6.000	*			
2.020	+/- .010	2.020	*			
.253	+/- .010	.253	*			
.621	+/- .010	.621	*			

Measured by: RB	Audited by: En	Prototype Approval: MA
Date: 07-09-18	Date: 07/09/18	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	34605
Description: PANEL		Part Number:	D3245-1
Inspection Dwg: 3245 - Rev: -A		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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[illegible]

Measured by: <b>MB</b>	Audited by:	Prototype Approval:
Date: <b>07-09-18</b>	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	